

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008462**Date Inspected:** 08-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Lv Li Qing / Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

Flux Cored Arc Welding (FCAW) of weld joint SEG 052A SSD016 – PP74 for OBG weld number 013 for Segment 9BE. The ZPMC welder identified as 055491 was welding in the 3G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) of weld joint SEG 052A SSD016 – PP74 for OBG weld number 130 for Segment 9BE. The ZPMC welder identified as 044795 was welding in the 3G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

On this date the QA inspector observed ZPMC personnel installing FL1 floor beam segment at the PP91 location for SEG. 10BE.

On this date the QA inspector observed ZPMC personnel installing FL1 floor beam segment at the PP92 location

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for SEG. 10CE.

On this date the QA inspector observed ZPMC personnel installing Side Panel segment for SEG. 9BW.

Flux Cored Arc Welding (FCAW) of CA058 weld joint CSD5 – PP73 for OBG Corner Assembly weld numbers 013 ~ 022 for Segment 9AE. The ZPMC welders identified as 051356 and 055564 were welding in the 2F position.

The ZPMC QC identified as Geng Wei was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of CA058 weld joint CSD2 – PP72.5 for OBG Corner Assembly weld numbers 043 ~ 048 for Segment 9AE. The ZPMC welders identified as 051356 and 055564 were welding in the 2F position.

The ZPMC QC identified as Geng Wei was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of CA059 weld joint CSD3 – PP74 for OBG Corner Assembly weld numbers 082 and 084 for Segment 9BW. The ZPMC welder identified as 201215 were welding in the 2G position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2232-Tc-U4b-F.

Shielded Metal Arc Welding (SMAW) of CA059 weld joint CSD3 – PP76 for OBG Corner Assembly weld numbers 120 ~ 127 for Segment 9BW. The ZPMC welder identified as 205718 were welding in the 4F position. The ZPMC QC identified as Li Ming Yang was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2114-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	McClendon,Timothy	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
